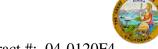
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-009647 Address: 333 Burma Road **Date Inspected:** 28-Aug-2009

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: CWI Present: Yes Mr. Liu yang/ Mr. Xu le feng No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** Tower

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 11

- 1. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040775 perform SMAW welding on, Inter connecting corner splice plate, Weld joint no. ESD1-SPSA3-55. ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-2G(2F)-Repair.
- 2. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068250 perform SMAW welding on, Spare strut web to flange, Weld joint no. WD1-A 6001-4-11B. ZPMC CWI Identified as Mr. Xu le feng. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2212-TC-U5B.
- 3. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 068865 perform FCAW welding on, Doubler plates of Skin A, West tower, Lift 4, Weld joint no. WSD1-FASA4-2 B/E-15. ZPMC CWI Identified as Mr. Peng guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4332-TC-p4-F.
- 4. This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

perform FCAW welding on, Inside Esat tower, Lift 4, Fit lug to Skin C Diaphragm, Weld joint no. ESTL3-4 B/K-69. ZPMC CWI Identified as Mr. An ging ching. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-3F-Repair.

Visual Inspection Testing:

This QA inspector performed Random Visual Inspection (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as East tower, Lift 3, 85.25 mtr., 92.5 mtr. And 95.5 mtr. Diaphragm to skin B/C, Fit lugs. The weld designations reviewed are as follows:

ESTL3-4 J/K-47 to 54, 62, 63, 66 to 71 -102.5 mtr. Fit lugs ESTL3- 4 J/K- 123 to 130, 140 to 147- 105.5 mtr. Fit lugs

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer